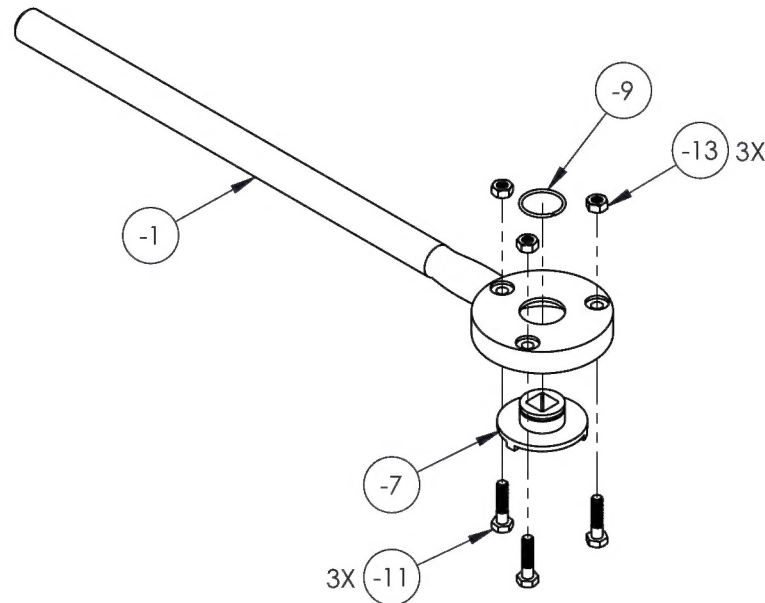


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/24/2016	RJC	JAG



NOTE:
REF. AIRBUS T/N 105-31501W5.



TITLE
ASSEMBLY/DISASSEMBLY FIXTURE

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	DWG NO.	REV
	X		-1	1	HANDLE WELDMENT			2	RBE105-31501W5	1
	1		-3		TUBE	1018/1020 CR		3		
	1		-5		RING	4140/4142		4		
			-7	1	SOCKET	4140/4142		5		
		B/O	-9	1	RND. WIRE SNAP RING	STEEL	Ø15/16 SHAFT X .874 I.D. X .064 C.S. (AR CON RINGS & SPECIALTY #1000-93)	1		
		B/O	-11	3	CAP SCREW	STEEL	M6 X 1 X 25mm CLASS 10.9 (MCMaster-CARR #91310A334)	1	QA APPR: LINDSAY	USED ON MODEL EC145
		B/O	-13	3	HEX NUT	STEEL	M6 X 1 CLASS 10 (MCMaster-CARR #92497A350)	1	APPROVED: GILBERT	
	ASSY -1								SCALE 1:4	DATE 8/17/2016

MAT'L
TREAT
FINISH
SPEC

DRAWN BY: CLOUGH
CHECKED: DUERFELDT
OPPS APPR: ANDERSON

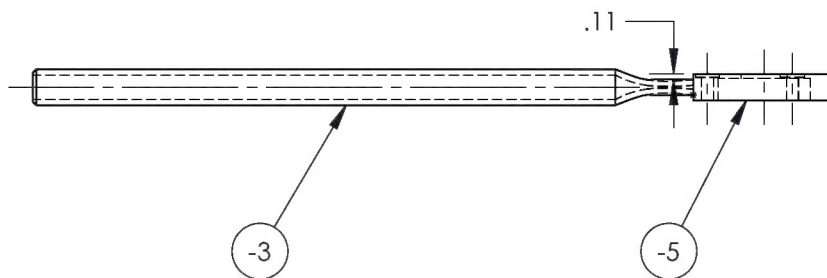
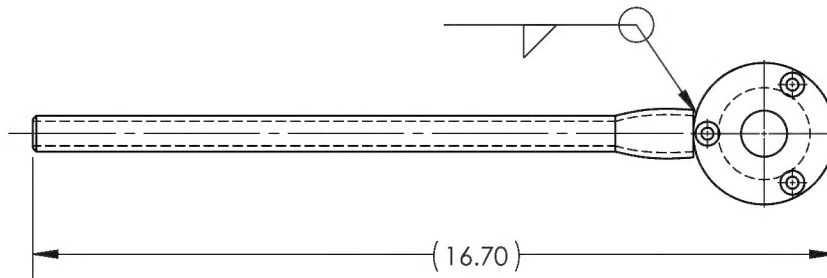
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± .5°
.X ± .1 SURFACES = 125°

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

SHEET 1 OF 5

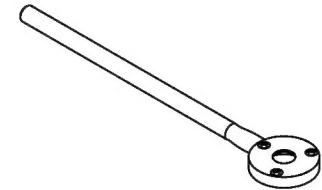
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



(-1)

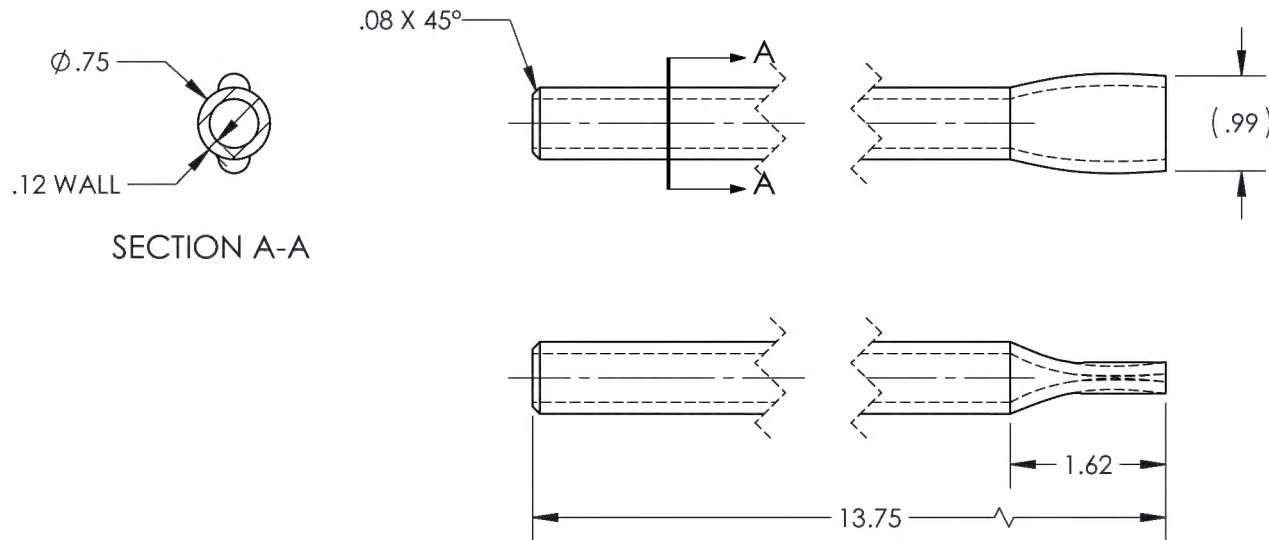
HANDLE WELDMENT



DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-1	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125
HEAT TREAT ZINC PLATE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
FINISH ZINC PLATE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SPEC ASTM B633 TYPE I SC 2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 8/17/2016
SHEET 2 OF 5	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

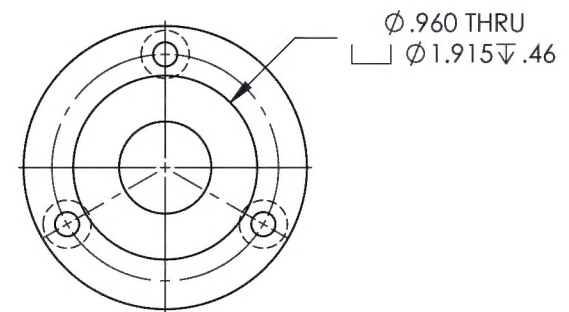
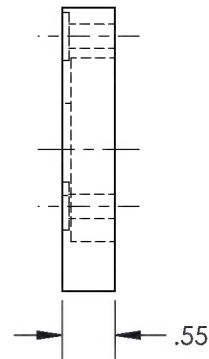
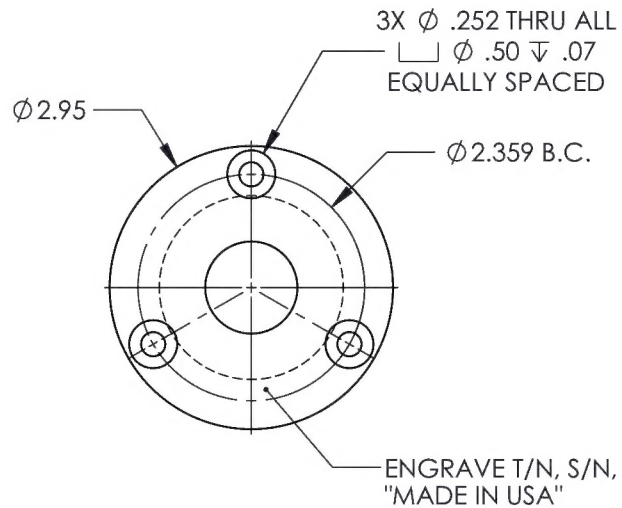
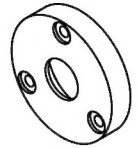
(-3)

TUBE

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-3	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC 145
SCALE 1:2	DATE 8/17/2016
	SHEET 3 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

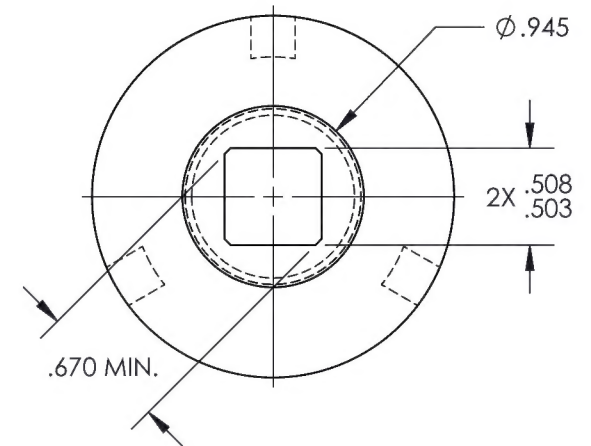
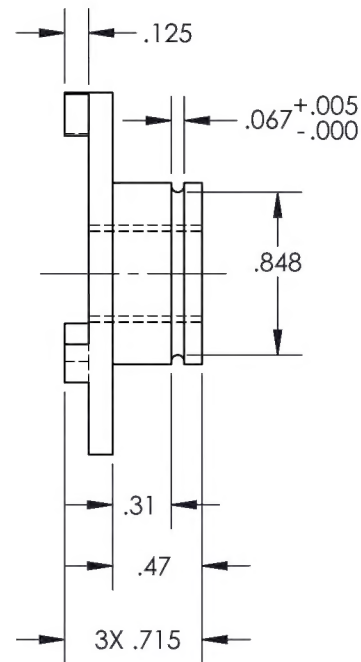
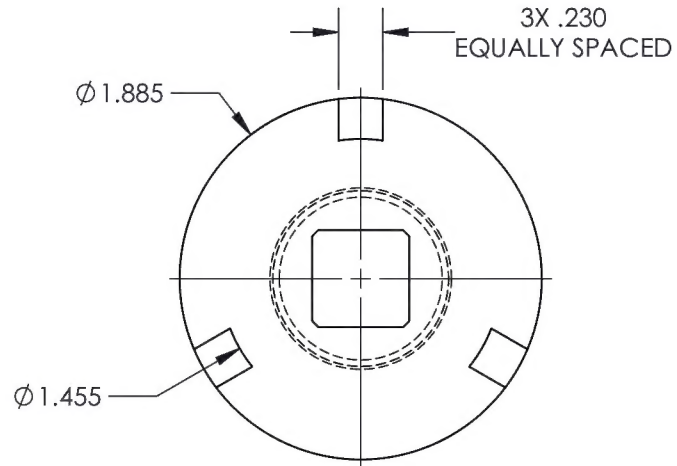
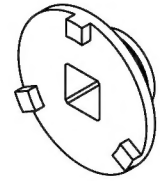


(-5)
RING

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC145
SCALE 1:2	DATE 8/17/2016
	SHEET 4 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:
TIMING NOT CRITICAL.

(-7)
SOCKET

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-7	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 40-45	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/17/2016	USED ON MODEL
SHEET 5 OF 5	EC145